Work Order ID 117217

April-24-14 10:11:11 AM

117217

Item ID: D2565-205 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Strut

Start Date: 4/23/14 **Start Qty:** ~~6.00~~ 7 *6*

Required Date: 4/23/14 **Req'd Qty:** 6.00 *6*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MLS **Date:** 14-04-29 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2565	Rev E								14/oc/co
100		0.00							
100	NC BRAKE				DAS 30 9-89	7			
Brake NC	**Memo**	0.00							
Brake NC	Punch as per Dwg D2565 using DT 8313								
110		0.00							DAS 36 9-89
110	Small Fab					~~7~~ x			14/09/24
Small Fab	**Memo**	0.00							
Small Fab	Drill hole as per Dwg D2565 (one end only) Deburr and polish								
120	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89 14-9-24
120						(7)			
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Work Order ID 117217

April-24-14 10:11:11 AM

117217

Item ID: D2565-205 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID:

Item Name: Strut **Stop** *NS2*

Start Date: 4/23/14 **Start Qty:** 6.00 *6*

Required Date: 4/23/14 **Req'd Qty:** 6.00 *6*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel M12984	0.00				7	0	14-9-30	DAS 34 9-89
130	**Memo**	0.00							
Powdercoat	START TIME: 3:35								
Powder Coating	OVEN TEMPERATURE: 400°								
	FINISH TIME: 4:05								
140	QC3- Inspect Part Finish	0.00				7		OP	14/10/01
140	**Memo**	0.00							
QC									
Quality Control									
150	Identify as per dwg & Stock Location: 53554	0.00				7x		DAS 26 9-89	SEP 30 2014
150	**Memo**	0.00							
Packaging									
Packaging									

DQA: _____ Date: _____

DART AEROSPACE

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Work Order: _____

Part No. _____

NCR No. _____

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Scrap ☐
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Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

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Large Fab ☐ Composite ☐ Supplier ☐

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Doc/Data	☐									
Equip/Tooling	☐									
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Work Order ID 117217

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Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	**Memo**	0.00							
Quality Control									

MCJ 14-10-01

MCJ 1470-01

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

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Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

April-24-14 10:11:14 AM

Work Order ID: 117217

117217

Parent Item: D2565-205

D2565-205

Parent Item Name: Strut

Start Date: 4/23/14 **Required Date:** 4/23/14

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP: E 01.08.28Added Powder coat, and added Inspetion Levels 3 and 21.SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	170.7591	1.7916 DAS 30 ~~9.89~~ **	11.31537	7	14/06/20	

M304TR0.750W.049

304 RD Tube .750 x .049W

Location	Loc Qty	Loc Code	
MAT017	170.7591		
122312	6		
124768	49.27		
M126183	26.0959		
M128084	89.3932		

M129188

16

DQA: _____ Date: _____

DART AEROSPACE

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DART AEROSPACE LTD

Description: Strut Work Order: 117217

Inspection Drawing: D2565 Rev: E Part Number: D2565-205

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.22	+/- 030	21.22	/		T	SB-5
20.42	+/- .030	20.42	/		T	SA-5
~~.316~~	+/- .005					

Measured by: DAS 30 9-89	Checked By: DAS 36 5-80	QC inspector:	Engineering Approval (*if necessary*)
Date 14/06/10	Date 14/06/10	Date	Date